

SPECIFICATION CONTROL DRAWING

REQUIREMENTS:

DIMENSIONS (FIGURE 1), DESIGN CHARACTERISTICS, AND CONFIGURATIONS MEET THE REQUIREMENTS OF M39029/76 EXCEPT THAT THE TEMPERATURE RATING IS 125°C INSTEAD OF 200°C. TERMINATION IS BY SOLDERING INSTEAD OF CRIMPING AND THE CABLE ACCOMMODATED IS TWISTED PAIR INSTEAD OF COAXIAL. SEE TABLE I FOR CABLE ACCOMMODATIONS.

THIS CONTACT IS QUALIFIED TO RAYCHEM SPECIFICATION D-6002.

MATING CONTACT: D-602-0143 (M39029/77); D-602-0174 (M39029/78)

TOOLS: SEE TABLE II.

TABLE I. DESIGN CHARACTERISTICS

CABLE ACCOMODATED <u>1/</u>	CONTACT CAVITY SIZE	TYPE	CLASS
TWISTED PAIR 26 AWG TWISTED PAIR 28 AWG TWISTED PAIR 30 AWG	16	D	A

1/ OTHER APPLICATIONS USING DIFFERENT CABLES MAY BE ACCOMODATED. CONSULT CONTACT MANUFACTURER FOR DETAILS.

TABLE II. TOOLS

HEATING TOOLS <u>2/</u>	REFLECTORS <u>2/</u>	STANDARD FIXTURE <u>2/</u>		REPAIR FIXTURE <u>2/</u>	INSTALLING TOOLS	REMOVAL TOOLS	FOLDING TOOL
		BASIC FIXTURE	ADAPTER				
AA-400 SUPER HEATER	#979663 MINI SOLDER SLEEVE	AD-1319 OR AD1567	AT-1319-78 OR AT-1319-27	AD-1565	M81969/8-07 OR M81969/14-03	M81969/8-08 OR M81969/14-03	AD-1575-1
CV-5300 MINI GUN	MG-1 SOLDERSLEEVE						

2/ SEE TERMINATION PROCEDURE: RAYCHEM ES-61224

DOCUMENT NUMBER:

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CAD NAME: 001431-2

SHEET 2 of 5

SPECIFICATION CONTROL DRAWING

ASSEMBLY INSTRUCTIONS

1. STRIP CABLE AS SHOWN ON FIGURE 2.
2. INSERT CABLE INTO CONTACT UNTIL IT IS FULLY SEATED.
3. HEAT CONTACT WITH APPROPRIATE TOOLS AS SHOWN ON TABLE II UNTIL SOLDER MELTS AND STRAIN RELIEF TUBING CONFORMS TO CABLE.
4. SEE TABLE I FOR CABLE ACCOMMODATION.

TWISTED PAIR CABLE ACCOMMODATION

1. SOLDER TACTS CONTACTS CAN BE TERMINATED TO TWISTED-PAIR CABLE OF THE FOLLOWING CONSTRUCTION.

SIZE.....AWG 26 THROUGH AWG 30
PLATING.....TIN OR SILVER
CONSTRUCTION.....SOLID OR STRANDED
INSULATION DIAMETER..... ϕ .045 INCH. MAX.

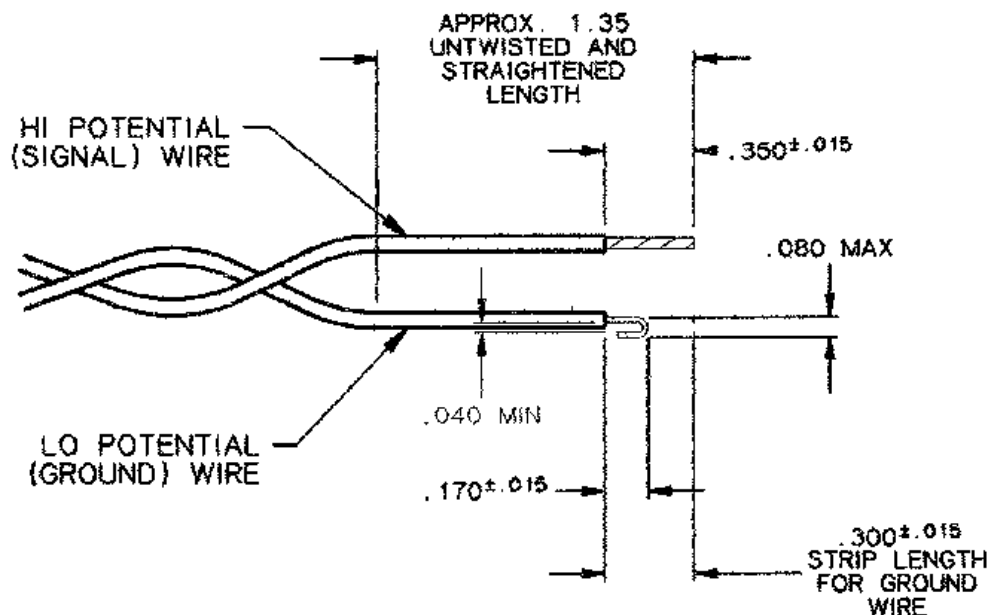


FIGURE 2

CONTACT ENGAGEMENT AND SEPARATION FORCES (INNER SOCKET CONTACT ONLY): THE ENGAGEMENT DEPTH SHALL BE AS ENCOUNTERED IN NORMAL SERVICE. THE TEST PINS SHALL BE IN ACCORDANCE WITH MS3197 EXCEPT THE DIAMETERS SHALL BE AS SPECIFIED IN THE FOLLOWING, AND SURFACE ROUGHNESS SHALL NOT EXCEED 3 MICROINCHES. PROVISIONS FOR CLEARANCE HOLE SHALL BE PROVIDED.

TABLE III

TEST PIN DIAMETER (INCH)	MINIMUM SEPARATION FORCE (OUNCES)		MAXIMUM ENGAGEMENT FORCE (OUNCES)	
	INITIAL	AFTER CONDITIONING	INITIAL	AFTER CONDITIONING
.0155 +.0002 -.0000	N/A	N/A	12.0	14.0
.0145 +.0000 -.0002	0.5	0.4	N/A	N/A

DIELECTRIC WITHSTANDING VOLTAGE (APPLIED BETWEEN INNER AND OUTER CONTACT):
 TEST VOLTAGE:

AT SEA LEVEL: 800 VAC. RMS.
 AT 50,000 FEET: 250 VAC. RMS.

CONTACT RESISTANCE SEE TABLE IV.

TABLE IV. CONTACT RESISTANCE

TEST CABLE	MAXIMUM VOLTAGE DROP (MILLIVOLTS)						TEST CURRENT (AMPS)	
	25° +3° -0° C		25° +3° -0° C 3/		125° +3° -0° C			
	CONTACT		CONTACT		CONTACT		CONTACT	
	INNER	OUTER	INNER	OUTER	INNER	OUTER	INNER	OUTER
26 AWG T.P./TC	52	52	63	63	78	78	2.0	2.0
28 AWG T.P./TC	54	54	65	65	81	81	1.5	1.5
30 AWG T.P./TC	60	60	73	73	90	90	1.0	1.0
26 AWG T.P./SHSC	52	52	63	63	78	78	2.0	2.0
28 AWG T.P./SHSC	54	54	65	65	81	81	1.5	1.5
30 AWG T.P./SHSC	60	60	73	73	90	90	1.0	1.0

3/ AFTER CONDITIONING.

TC = TIN PLATED COPPER
 TP = TWISTED PAIR
 SHSC = SILVER PLATED HIGH STRENGTH COPPER

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DOCUMENT NUMBER:

D-602-0142

CAD NAME: 001431-4

SHEET 4 OF 5

SPECIFICATION CONTROL DRAWING

LOW SIGNAL LEVEL CONTACT RESISTANCE (INNER CONTACT ONLY): SEE TABLE V.
 TENSILE STRENGTH (INNER AND OUTER CONTACT SOLDER JOINT): SEE TABLE V.

TABLE V. LOW SIGNAL LEVEL CONTACT RESISTANCE
 (INNER CONTACT ONLY) AND TENSILE STRENGTH

TEST CABLE	MAXIMUM CONTACT RESISTANCE (MILLIOHMS)		TENSILE STRENGTH (POUNDS) (MINIMUM)	
	INITIAL	AFTER CONDITIONING	INNER CONTACT	OUTER CONTACT
26 AWG T.P./TC	31	38	5.0	5.0
28 AWG T.P./TC	50	60	3.0	3.0
30 AWG T.P./TC	75	88	1.5	1.5
26 AWG T.P./SHSC	31	38	5.0	5.0
28 AWG T.P./SHSC	50	60	4.0	4.0
30 AWG T.P./SHSC	75	88	2.0	2.0

TC = TIN PLATED COPPER
 TP = TWISTED PAIR WIRE
 SHSC = SILVER PLATED HIGH STRENGTH COPPER

MATERIAL:	CONTACT BODY	BERYLLIUM COPPER, ALLOY 173, CONDITION H PER ASTM B196
	INNER CONTACT	BERYLLIUM COPPER, ALLOY 173, CONDITION H PER ASTM B196
	PLATING (CONTACT BODY AND INNER CONTACT)	GOLD PLATE PER MIL-G-45204 TYPE II, GRADE C 50 MICROINCHES MINIMUM OVER NICKEL PER QQ-N-290A 50 MICROINCHES MINIMUM OVER COPPER STRIKE - 40 MICROINCHES MAXIMUM
	SOLDER	Sn63 PER QQ-S-571
	FLUX	TYPE RMA PER QQ-S-571
	SHRINK TUBING	HEAT-SHRINKABLE, RADIATION-CROSSLINKED POLYVINYLIDENE FLUORIDE
	DIELECTRIC	ETFE FLUOROPOLYMER PER ASTM D3159
SHIPPING	FIGURE 1 INDICATES THE ONE-PIECE ASSEMBLY. TERMINATION INSTRUCTIONS ARE TO BE SHIPPED WITH THE UNIT PACKAGE.	